

Work Order ID 160080

Thursday, April 20, 2017 2:05:13 PM

160080

Page 1

Item ID: D5344-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bell Medium Main Rotor Tie Down - Tie Down Assembly
Start Date: 4/20/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/21/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: DAS 21 Date: APR 20 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5344	REV A ✓								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	1.78							
Small Fab	CUT TWO HOLES IN BALL AS PER NOTE 8								
	ASSEMBLE AS PER NOTE 8,9 AND 10								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

4

SEP 19 2017

DAS
6
9-89DAS
30
9-89

4

SEP 20 2017

120

DAS
16
9-89

17/09/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
2016 10 2017				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐	

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>JX442</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

SEP 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 160080

160080

Parent Item: D5344-041

D5344-041

Parent Item Name: Bell Medium Main Rotor Tie Down - Tie Down Assembly

Start Date: 4/20/2017

Required Date: 4/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 16.06.06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5339-1 *D5339-1* Carabiner Clip		Manufactured	No			110	Each	4.0000	1	4			
									**			SEP 19 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST164				4					
				147097				4		162172		SEP 19 2017	DAS 6 9-89
D5340-1 *D5340-1* Tennis Ball		Manufactured	No			110	Each	85.0000	1	4			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST443				85					
				147201				85		4		SEP 19 2017	DAS 6 9-89
D5341-1 *D5341-1* Nylon Rope		Manufactured	No			110	f	174.0000	18	72			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST443				174					
				155234				174		72		SEP 19 2017	DAS 6 9-89
D5342-1 *D5342-1* Rope Clamp		Manufactured	No			110	Each	13.0000	1	4			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST443				13					
				147866				13		4		SEP 19 2017	DAS 6 9-89

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____		Work Order update only ☐																															
Work Order: _____ Part No. _____ NCR No. _____		<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2" style="text-align: center;">DISPOSITION</th> <th colspan="4" style="text-align: center;">AGAINST DEPARTMENT/PROCESS</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">Rework ☐</td> <td style="text-align: center;">☐</td> <td style="text-align: center;">Skid-tube ☐</td> <td style="text-align: center;">Cross tube ☐</td> <td style="text-align: center;">Water Jet ☐</td> <td style="text-align: center;">Engineering ☐</td> </tr> <tr> <td style="text-align: center;">Scrap ☐</td> <td style="text-align: center;">☐</td> <td style="text-align: center;">Machining ☐</td> <td style="text-align: center;">Small Fab ☐</td> <td style="text-align: center;">Prod. Eng. Coord. ☐</td> <td style="text-align: center;">Quality ☐</td> </tr> <tr> <td style="text-align: center;">Use-as-is ☐</td> <td style="text-align: center;">☐</td> <td style="text-align: center;">Thermoforming ☐</td> <td style="text-align: center;">Finishing ☐</td> <td style="text-align: center;">Rec/Store/Packaging ☐</td> <td style="text-align: center;">Other ☐</td> </tr> <tr> <td style="text-align: center;">Suspected Unapproved ☐</td> <td style="text-align: center;">☐</td> <td style="text-align: center;">Large Fab ☐</td> <td style="text-align: center;">Composite ☐</td> <td style="text-align: center;">Supplier ☐</td> <td style="text-align: center;">☐</td> </tr> </tbody> </table>		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Rework ☐	☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Scrap ☐	☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Use-as-is ☐	☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Suspected Unapproved ☐	☐	Large Fab ☐	Composite ☐	Supplier ☐	☐
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Picklist Print

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Work Order ID: 160080

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Parent Item: D5344-041

D5344-041

Parent Item Name: Bell Medium Main Rotor Tie Down - Tie Down Assembly

Start Date: 4/20/2017

Required Date: 4/21/2017

Start Qty: 4.00

Required Qty: 4.00

D5343-1

Manufactured No

110

Each

26.0000

1

4

D5343-1

Long Hook

Location

Loc Qty

Loc Code

DT443

5

147204

5

ST443

21

147888

21

SEP 19 2017

DATE
9-8-17

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Shop Packet Print

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DQA: _____ Date: _____



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Description Work Order Deviation				Disposition					
							Completed By Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____ _____ _____			
Misidentified ☐	☐	Past Due	☐				